

Work Order ID 78047

78047

Page 1

December-28-11 8:13:18 AM

Item ID: D4148-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Crosstube Lug Assembly, Fwd
 Start Date: 28/12/2011 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 12/01/2012 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/28 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4148	D								
100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1 - Assemble as per dwg								
	<i>pick hit</i>								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location	0.00							
120									
Packaging	Memo	0.00							
Packaging									

12/01/12 (6)
12/01/12 (6)

Sizalio

(x6)

468

(6x) *SP12-01-13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

OK 12/01/13

MF
12-01-13

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

December-28-11 8:13:22 AM

Page 1

Work Order ID: 78047

78047

Parent Item: D4148-041

D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

10.10.29 as per revC DD verf:EC

AS PER DWG REV.D DD VERF:EC

IPP Rev:C

IPP REV:D 11.03.02

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3		Purchased	No			100	Each	1,469.000	4	12			
MS21043-3									**				
Nut													

Location	Loc Qty	Loc Code
FG	72	
103691	72	
ST300	750	
119901	750	
ST301	647	
118077	2	
118614	441	
118686	30	
119758	174	

MS21043-4

Purchased

No

100

Each

1,275.000

1

18

MS21043-4

Nut

Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST300	470	
118686	470	
ST301	765	
119309	269	
119546	496	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 78047

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Parent Item: D4148-041

D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 6.00

Required Qty: 6.00

D2690-6 Manufactured No

100 Each

5.0000

1

6

D2690-6

Lanyard Assembly

**

Location

Loc Qty

Loc Code

ST020

5

74515

5

100 Each

8.0000

1

6

D3910-1

Manufactured No

D3910-1

Crosstube Lug

**

Location

Loc Qty

Loc Code

st507

8

73527

8

100 Each

23.0000

1

6

D4091-1

Manufactured No

D4091-1

Mounting Lug

**

Location

Loc Qty

Loc Code

ST458

20

77320

20

ST460

3

69605

3

100 Each

2.0000

2

12

D4148-1

Manufactured No

D4148-1

Crosstube Lug Plate, Fwd

**

Location

Loc Qty

Loc Code

ST133

2

70161

2

100 Each

0.0000

1

6

D4148-3

Manufactured No

D4148-3

Stud Receiver, Lower

**

December-28-11 8:13:22 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Page 3

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Parent Item: D4148-041

D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 6.00

Required Qty: 6.00

D4148-5 Manufactured No

100 Each 5.0000 1 6

D4148-5

Eyebolt Stud

**

78 338 1x

Location

Loc Qty

Loc Code

ST133

5

71932

5

71932 5x

AN3C12A Purchased No

100 Each 64.0000 2

AN3C12A

Bolts

**

12 ✓

Location

Loc Qty

Loc Code

ST351

64

117514

4

118112

5

118422

17

118451

22

119510

16

118422 5x

119510 3x

AN4C13A Purchased No

100 Each 15.0000 3 18

AN4C13A

BOLT

**

1120487 15x

Location

Loc Qty

Loc Code

ST357

15

118838

15

118838 3x

MS17984-C413 Purchased No

100 Each 8.0000 1 6

MS17984-C413

PIN, QUICK RELEASE

**

120123 3x

12/1/12

Location

Loc Qty

Loc Code

ST315

8

114340

1

118612

2

119623

5

119623 3x

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Parent Item: D4148-041

D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 6.00

Required Qty: 6.00

MS20615-4M18 Purchased No

100 Each

428.0000 8 48

MS20615-4M18

Rivet

**

11/4808 35X

Location

Loc Qty

Loc Code

ST323

428

118077

243

118543

185

NAS1149C0332R Purchased No

100 Each

4,283.000 4

NAS1149C0332R

Washer

**

118543 3X

Location

Loc Qty

Loc Code

ST297

4283

118354

705

119124

12

119736

3566

NAS1149C0432R Purchased No

100 Each

3,780.000 6

NAS1149C0432R

Washer

**

119736

12/01/9 (6)

Location

Loc Qty

Loc Code

ST297

3780

117291

2780

119124

1000

117291

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

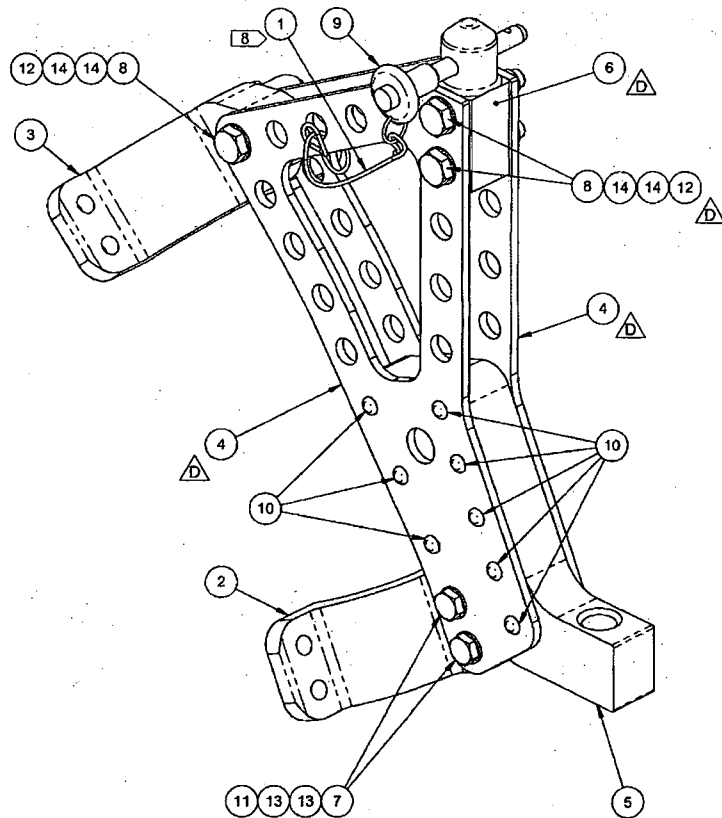
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4148-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
- 7) WEIGHT: 3.67 lbs
- 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	2	AN3C12A	BOLT
8	3	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	8	MS20615-4M18	RIVET
11	2	MS21043C3	NUT
12	3	MS21043C4	NUT
13	4	NAS1149C0332R	WASHER
14	6	NAS1149C0432R	WASHER

RECEIVED
FROM
UNCONTROLLED
SUBJECT TO
WITH
VENDOR
NO 78047 M.C.J
11/12/28

RELEASED
2011-02-24

D	HOLE DIA CHANGED TO 0.257" (D8-3); HOLE DIA CHANGED TO 0.260" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, C4-2)	SC	11.02.22
C	REDESIGNED D4148-1/3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.129 3 PL REPLACES Ø0.129 3 PL (ZN D6-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS 0.129 (ZN C8-5); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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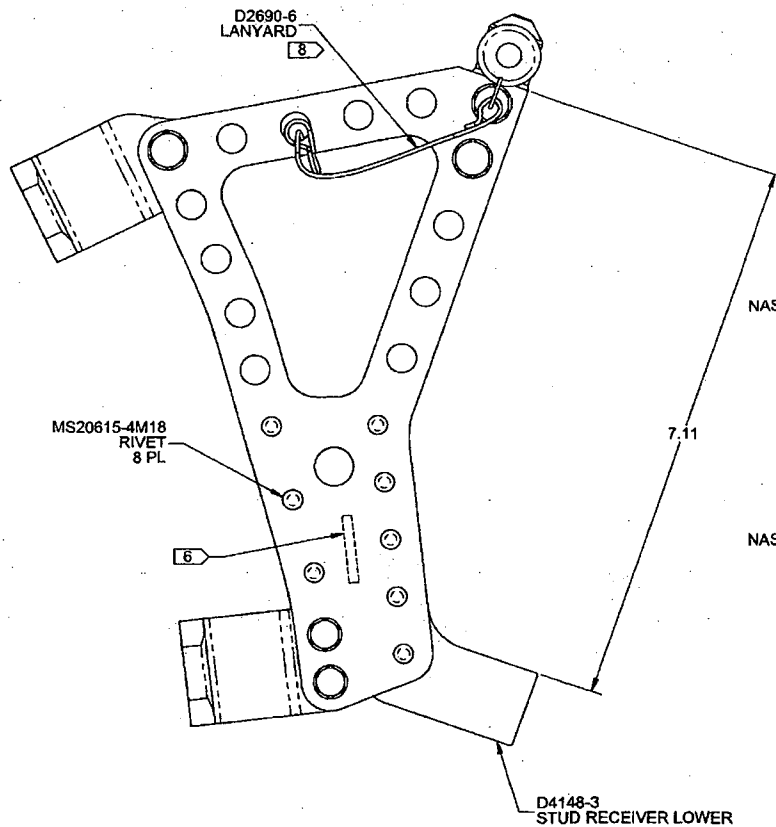
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

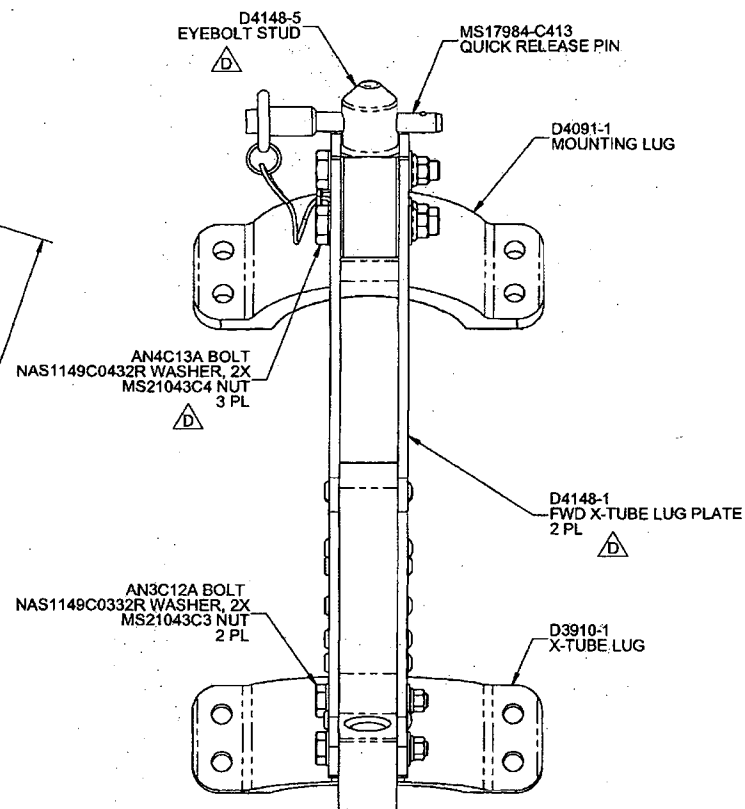
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NOTE: Date & initial all entries

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D4148-041 FWD X-TUBE LUG ASSY



RELEASED
2011-02-27

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4148	SHEET 2 OF 5
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DE APPR.		FWD X-TUBE LUG ASSY	NTS
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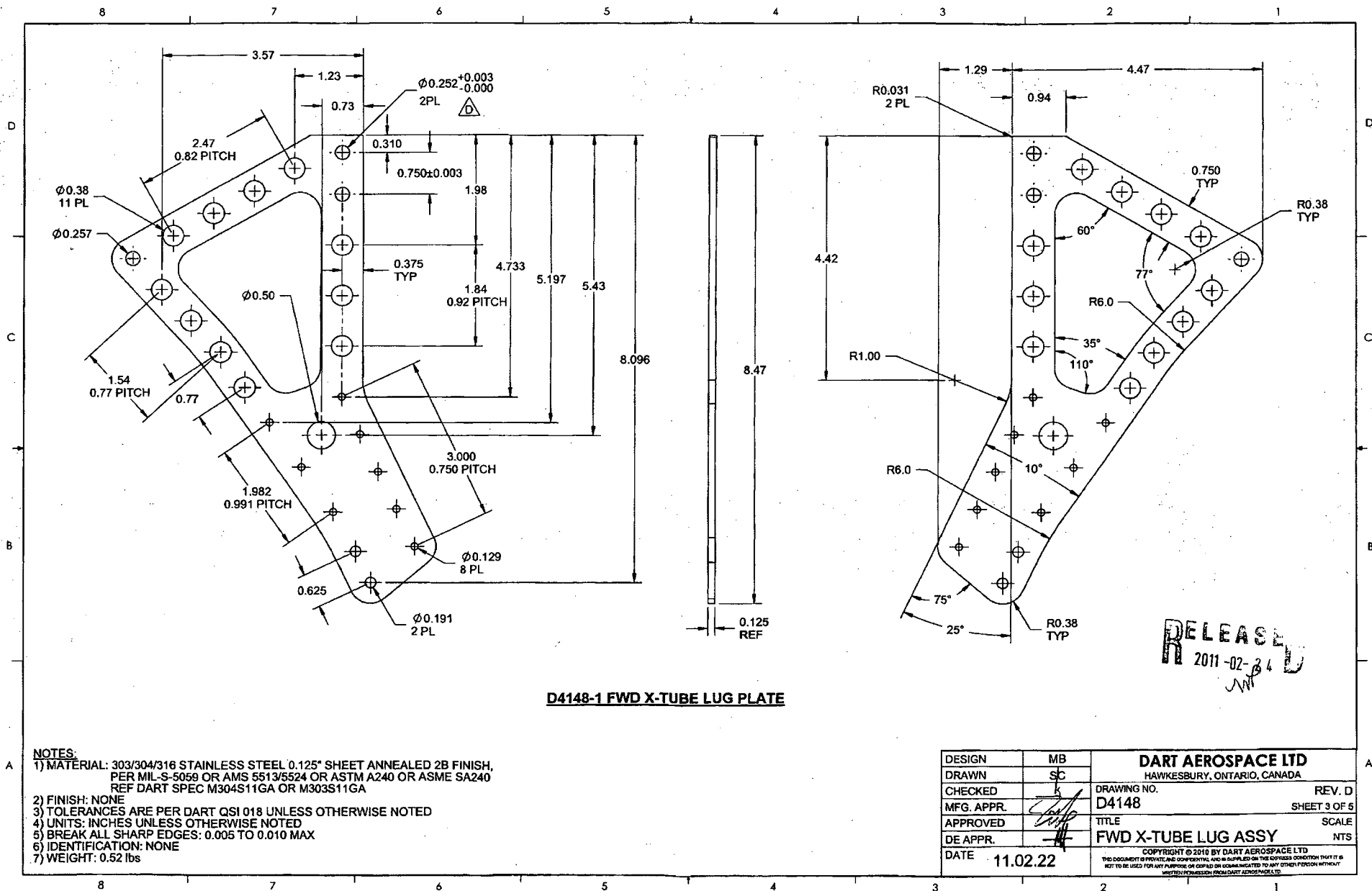
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72047



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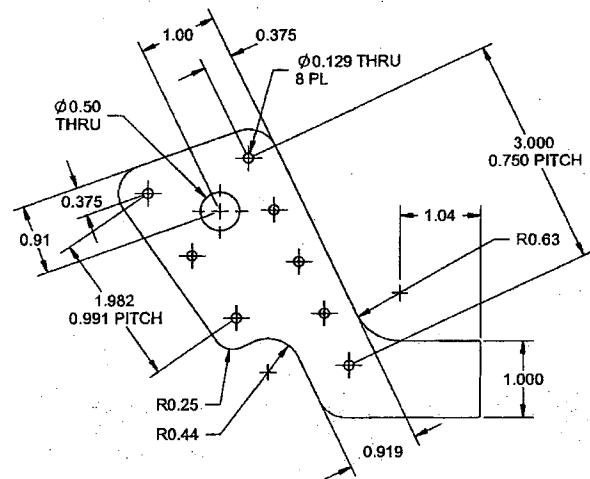
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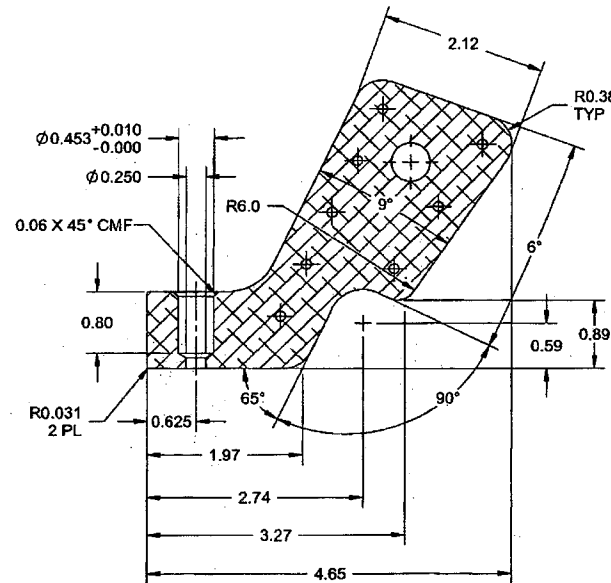
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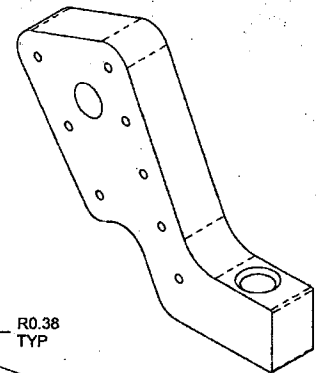
76047



D4148-3 STUD RECEIVER LOWER



SECTION A-A



RELEASED
2011-02-30

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.52 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4148	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
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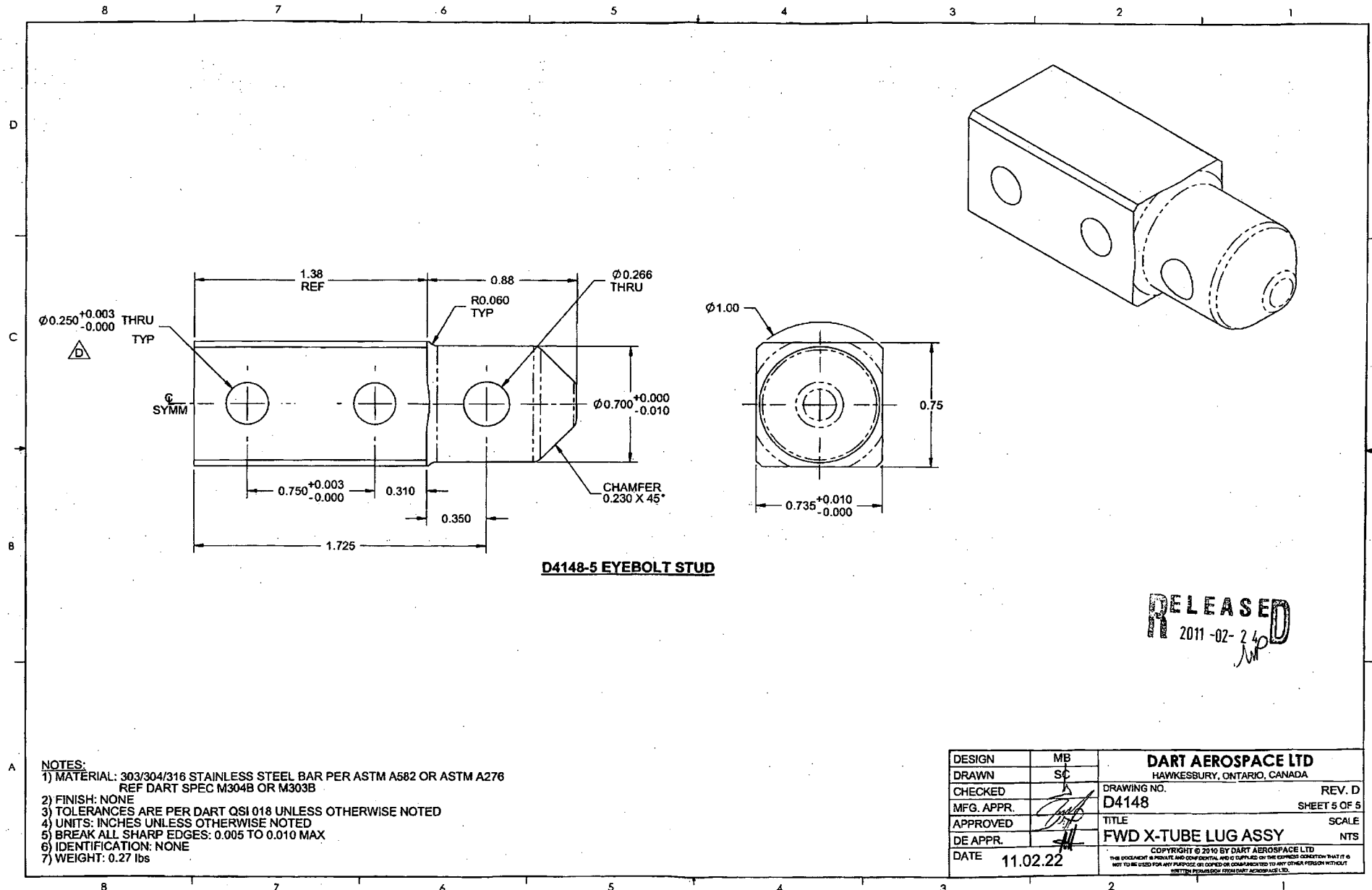
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Feoff



RELEASED
2011-02-24

- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.27 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 5 OF 5
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DE APPR.		FWD X-TUBE LUG ASSY	NTS
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